



NO
41363

WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

UNCONTROLLED COPY
RETURN TO
ENGINEERING
SHOP COPY
RETURN TO
ENGINEERING

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 18/08/2008 3:44:10 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT BLADE FOLD ASSY WELDMENT

Job Number: 41363

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/23 *af*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-10-22

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Job Number: 41363

Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

D344013

Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bracket

batch:-

B41452

Cpl 08-10-20

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- assemble parts on jig DT8814 and weld as per dwg PB67-43001

** ensure no burn thru after welding in tube -235 and -229 only where bushing -265 ***

SP 08.10.20

Cpl 08-10-20

15.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

08/10/21 (2)

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/21 (82)

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

in detail D, mask in between -311 prior to paint

mask 1.750" on the end of -243 prior to paint

mask inside of D3440-9 prior to paint

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00
320 OF
1:30

M-L 08/10/21

(2X)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/21 (2)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Cpl 08-10-21

Dart Aerospace Ltd

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Part Number: PB674300109

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PB6743001235

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Outer Tube

batch:- B41490

2

Cpl08-10-20

7.0

PB6743001229

Outer Tube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Outer Tube

batch:- B41489

2

Cpl08-10-20

8.0

PB6743001213

Flanged Hook



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Flanged Hook

batch:- ~~B41488~~ 4 mx B41488

4

Cpl08-10-20

9.0

PB6743001311

Restraint



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Restraint

batch:- B41211

8

Cpl08-10-20 - Pat E.

10.0

PB6743001277

Contoured Hinge Arm



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Contoured Hinge Arm

batch:- B41499

4

Cpl08-10-20

11.0

PB6743001243

Handle Arm Extension



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Handle Arm Extension

batch:- B41024 2 mx B41024

4

Cpl08-10-20

12.0

D34409

Tube Detent Clip Base



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Tube Detent Clip Base

batch:- B41205

4

Cpl08-10-20

Dart Aerospace Ltd

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QA: N/C Closed: _____ Date: _____

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Date: Monday, 18/08/2008 3:44:10 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: AFT BLADE FOLD ASSY WELDMENT
Job Number	: 41363		
Estimate Number	: 13503		
P.O. Number	:	Part Number	: PB674300109
This Issue	: 18/08/2008 S.O. No. :	Drawing Number	: B6743001 P.6
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B1
Previous Run	: 40772	Material	:
Written By	:	Due Date	: 18/09/2008
Checked & Approved By	: <u>RP08-8-18</u>	Qty:	28 Um: Each
Comment	: Est Rev:A 08-06-25 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB6743001211	Square Tubing
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 48.0000 Each(s)

Square Tubing

batch: 341487

2.0	PB6743001209	Square Tubing
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tubing

batch: ~~B41487~~ x 2m B40595 x 2m

3.0	PB6743001201	Square Tubing
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Comment: Qty.: 2.0000 Each(s)/Unit Total: 18.0000 Each(s)

Square Tubing

batch: B41572

4.0	PB6743001203	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tube

batch: ~~B40595~~ x 1m 41769 x 2

5.0	PB6743001239	Square Tube
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 8.0000 Each(s)

Square Tube

batch: B41909